

Date: Tuesday, 7/24/2007 10:45:54 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STIFFNER
Job Number : 33720	
Estimate Number : 12955	
P.O. Number :	Part Number : D36391
This Issue : 7/24/2007 S.O. No. :	Drawing Number : D3639 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0005
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 33719	Material :
Written By : <i>JLM 07-07-24</i>	Due Date : 7/31/2007 Qty: 2 Um: Each
Checked & Approved By :	Verified By: EC
Comment : Est Rev.A New Issue 07-07-20 JLM	

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2510 sf(s)/Unit Total : 0.5019 sf(s)
 2024-T3 .050 sheet
 Batch: *M103321* *IB 07-07-36*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3639
 Dwg Rev: *PROTO*
 Prog Rev: *TYPE*

IB 07-07-30

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 07-07-36*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 C'sink as per Dwg D3639

*IB 070731**(2)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFNER

Job Number: 33720

Part Number: D36391

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

Handwritten: 070731

Handwritten: 2

7.0

QC5

**ENGINEERING
APPROVAL**

INSPECT WORK TO CURRENT STEP



Handwritten: 070808

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: N/A

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 07108/15

Job Completion



FOR ENGINEERING USE ONLY

Handwritten: w/o 00104

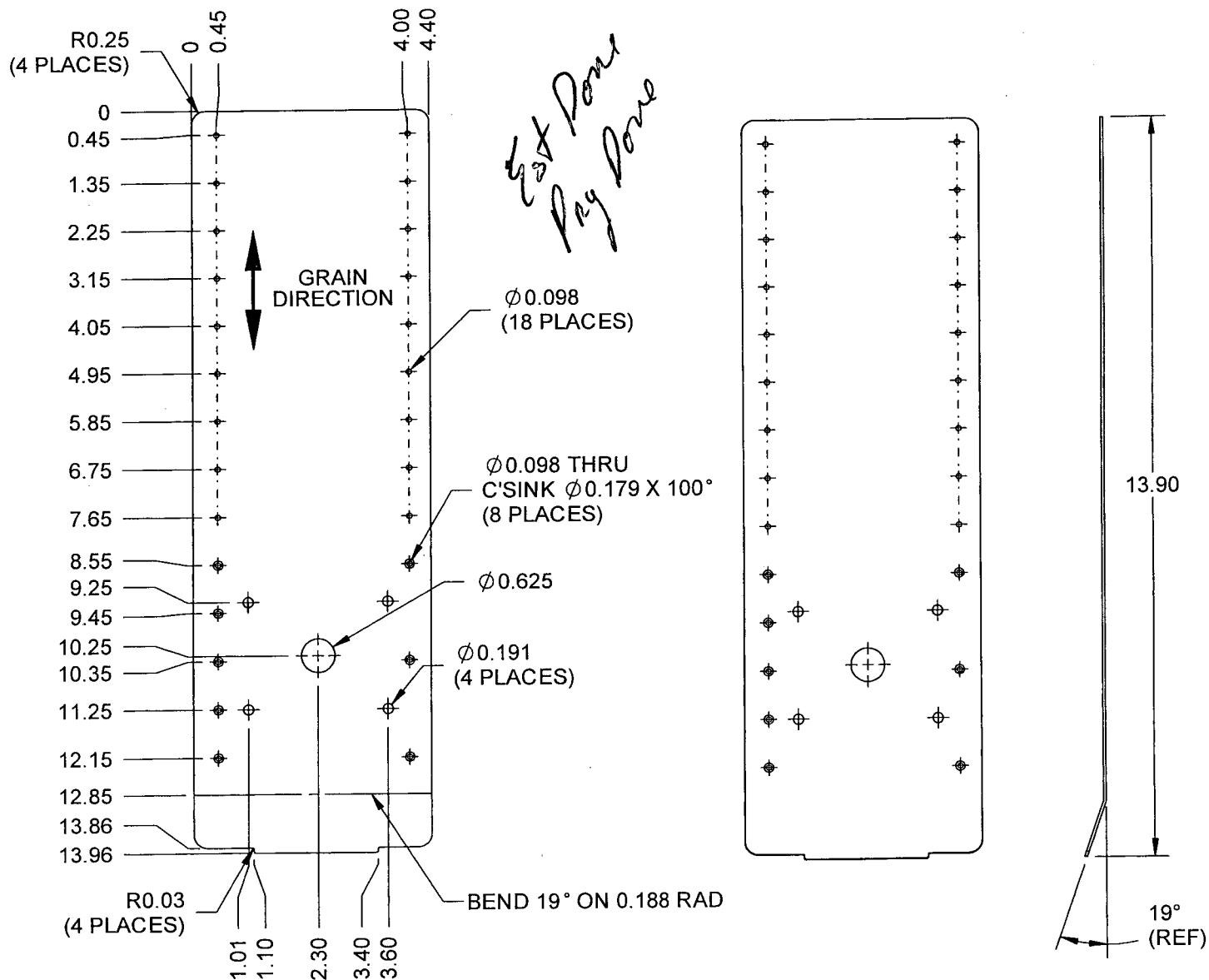
Handwritten: V

Handwritten: 070815

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

LE 07-07-17

DESIGN TS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED	DRAWING NO. D3639	REV. A SHEET 2 OF 2
DATE 07.06.25		TITLE STIFFENER	SCALE 1:3



**D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)**

**D3639-3 STIFFENER
(WAS GENEVA P/N G10604-5)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-4)**

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order:	33780
Description: <u>STIFFNER</u>		Part Number:	D3639-3
Inspection Dwg:	Rev: <u>PROTOTYPE</u>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.45	+/- .030	1.45	*			
1.35	+/- .030	1.35	*			
2.25	+/- .030	2.25	*			
3.15	+/- .030	3.15	*			
4.05	+/- .030	4.05	*			
4.95	+/- .030	4.95	*			
5.85	+/- .030	5.85	*			
6.75	+/- .030	6.75	*			
7.65	+/- .030	7.65	*			
8.55	+/- .030	8.55	*			
9.25	+/- .030	9.25	*			
9.45	+/- .030	9.45	*			
10.25	+/- .030	10.25	*			
10.35	+/- .030	10.35	*			
11.25	+/- .030	11.25	*			
12.15	+/- .030	12.15	*			
12.85	+/- .030					
13.86	+/- .030	13.86	*			
13.96	+/- .030	13.96	*			
1.01	+/- .030	1.01	*			
1.10	+/- .030	1.10	*			
2.30	+/- .030	2.30	*			
3.40	+/- .030	3.40	X			

Measured by: <u>IB</u>	Audited by:	Prototype Approval:
Date: <u>07-07-30</u>	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

